

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017564**Date Inspected:** 20-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #16

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 08, 09 located on Crash Barrier, W5-SB5A-001. Welder is identified as 201905. ZPMC Quality Control Inspector (QC) is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

Witness of Ultrasonic Testing (UT)

This QA inspector Witnessed 100% UT performed by ZPMC Quality Control personnel. The member is identified as Crash Barrier, OBG Component. The component and weld designation identified as follows:

W5 –SB1 -011 – 019

W5 –SB1E -001 -081

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W5 –SB6A -001 -050

Bay #19

This QA Inspector observed the following work in progress

Heat Straightening:

Heat Straightening being performed on Bike Path identified as BK004A - 005 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Xu Tao who was present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 9501.

Bay #14

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 015 located on Lift 13 Component 13CE –SEG 3011A. Welder is identified as 054013. ZPMC Quality Control Inspector (QC) is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2214 –B-U2-FCM-1.

Weld joint # 016 located on Lift 13 Component 13CE –SEG 3011A. Welder is identified as 049339. ZPMC Quality Control Inspector (QC) is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2214 –B-U2-FCM-1.

Weld joint # 003 located on Lift 13 Component 13BE –SEG 3009N. Welder is identified as 049339. ZPMC Quality Control Inspector (QC) is identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2214 –B-U2-FCM-1.

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

ORTHOTROPIC BOX GIRDER (OBG)

Weld joint # 004- located on Lift 13 component 13CW – SA 3232 -001. Welder is identified as 201981. ZPMC Quality Control Inspector (QC) is identified as Li Shi You. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231-B –U3 -F.

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For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer